

Work Order ID 58647

Wednesday, May 12, 2010 2:19:00 PM



Page 1

Item ID: D3685-041

Accept



Setup Start



Revision ID:

Stop



Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 5/13/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: UMF

Date: 10-5-12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3685

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EB10/06/23 (4)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685

2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3685

EB10/06/23 (4)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/06/04



130

Identify as per dwg & Stock Location: 139F

0.00



Packaging

Memo

0.00

Packaging

C 10/6/25 (4)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28 J
C 10/6/25

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Picklist Print

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Work Order ID: 58647

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Date: 5/13/2010

Required Date: 5/21/2010

Start Qty: 4.00

Required Qty: 4.00

AN3C12A

Purchased

No

110

Each

104.0000

4



Bolts

Location

Loc Qty

Loc Code

ST351

104

112314

104

D3684-047

Manufactured

No

110

Each

0.0000

1



FWD LEG ASS'Y

D3684-049

Manufactured

No

110

Each

0.0000

1



AFT LEG ASS'Y

D3687-3

Manufactured

No

110

Each

9.0000

1



MOUNT

Location

Loc Qty

Loc Code

ST080

9

46761

3

51096

6

D3692-1

Manufactured

No

110

Each

521.0000

8



SPACER

Location

Loc Qty

Loc Code

ST082

521

50736

113

51467

408

EP 5/10/06/23
4114761 (16x)

B58641 (4x) EP 5/10/06/23

B58639 (4x) EP 5/10/06/23

EP 5/10/06/23

4
EP 5/10/06/23

15
17

W/O:			WORK ORDER CHANGES					
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Start Qty: 4.00

Required Qty: 4.00

MS21043-3 Purchased No 110 Each 3,635.000 4



Nut



Handwritten signature and date 5/10/06/23

Location

Loc Qty

Loc Code

FG	80	
103691	80	
ST301	3555	
112314	3555	

Handwritten number 16

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Shop Packet Print

Page 2

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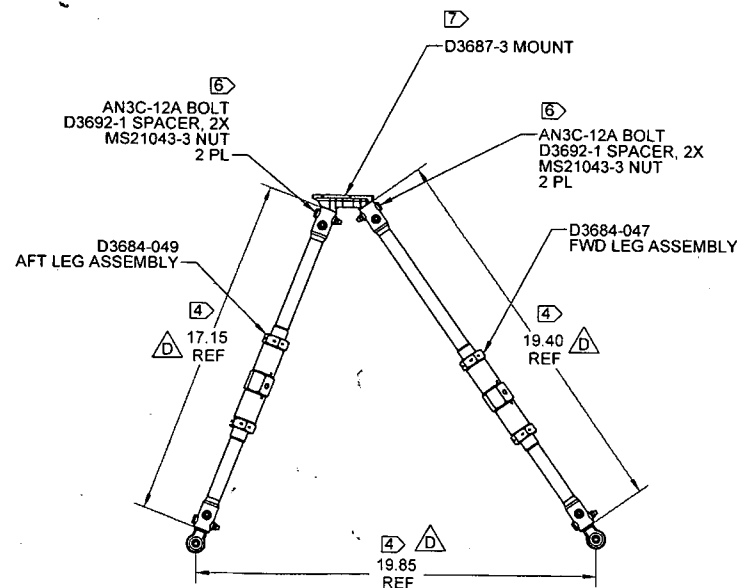
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

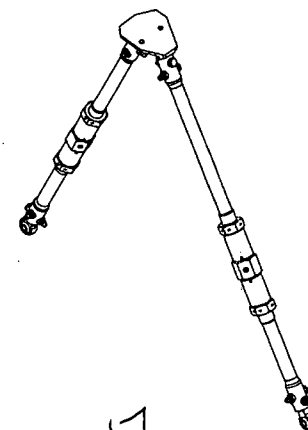
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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3685-041 BIPOD MOUNT ASSEMBLY



H58647

RELEASED
2010-03-15
NP

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3685 TITLE BIPOD MOUNT ASSEMBLY COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	#		
MFG. APPR.	#		
APPROVED	#		
DE APPR.	#	REV. D SHEET 1 OF 1 SCALE NTS	
DATE	10.03.03		

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